

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003607**Date Inspected:** 29-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1420**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** deck panels / skin plates and stiffeners/side pl**Summary of Items Observed:**

Heavy Duty Machine Shop – Bay 3:

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed ZPMC workers grinding on the following deck panels: DP378-001, DP459-001, DP135-001, and DP351-001. No welding was observed being performed. Present in this bay were ABF QC Kevin Ding, approximately 19 workers, and 28 panels.

Tower Shop – Bay 1

QA Inspector observed ZPMC personnel performing fit-up of stiffeners to SSD1-SA173/SA16 skin plate assembly and 200mm stitch weld in 500mm using SMAW with 7018 rod. Present in this bay were ABF QC's You Yuan Mao, Zhang Jiadi, ZPMC CWI Zhu Zhong Hai, and approximately 60 workers.

Sub Assembly – Bay 4

QA Inspector performed 10% verification final MT on the following rib to side plate welds SP195-001 - welds 002 to 013, SP650-001 - welds 022 to 031, SP646-001 - welds 022 to 031, SP308-001 welds 013 to 024, and SP302-001 - welds 002 to 013. No apparent indications were observed. Approximately 40 workers were present in this bay.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No significant conversations on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

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**Inspected By:** Goulet, George

Quality Assurance Inspector

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**Reviewed By:** Carreon, Albert

QA Reviewer